



Dynatex®

**Technical Datasheet
DYNA RTV RED 49202**

Revised Date: June 2011

Description

Red Hi-Temp RTV Silicone Gasket Maker is a paste-like, one-component material, which cures to a tough, rubbery solid upon exposure to moisture in the air. Formulated to withstand higher operating temperatures. Sensor safe and manufactured to meet OEM specifications. Resists cracks and migration caused by thermal cycling; will not leak; resists water, oil, and anit-freeze. Use on: Exhaust manifolds, exhaust crossover pipes, water pumps and thermostat housing.

Limitations

Red Hi-Temp RTV Silicone Gasket Maker will corrode or not adhere to copper, brass (and other copper-containing alloys), magnesium, zinc, galvanised metals (and other zinc-containing alloys). Red Hi-Temp RTV Silicone Gasket Maker has a good resistance to weathering, vibration, moisture, ozone and extreme temperatures. It may be applied in sub-zero weather without loss of extrusion or physical property characteristics and is effective to -35°C. Fully cured Red Hi-Temp RTV Silicone Gasket Maker can be used for temperatures up to 343°C.

How to Use

Red Hi-Temp Silicone Gasket Maker is supplied in ready-to-use form. It flows readily from its container under pressure. A spatula or wooden paddle can be used to tool the surface.

Typical Properties

Type	One Part Silicone Rubber
Physical Form	Non-Slumping Paste
Cure	Cure at room temperate on exposure to Water Valour in the air, giving off a small amount of acetic acid.
Operating Temperature	-35°C to 343°C
Primary Uses	General purpose sealing and bonding as a space filler rubber adhesive or a form-in-place Gasket Maker

As Supplied

Specific Gravity @ 25°C	1.04
Extrusion Rate (3.18mm orifice, 90 psi air pressure)	350 g/min
Tensile Strength (psi)	350
Flow rate (Sag or slump on 3.18 x 101.6mm bead) mm	NIL
Tack-free @ 25°C & 50% RH	16 to 20 Minutes
Cure time @ 25°C & 50% RH (3.18mm thickness),	24 Hours

ACTIVE & INACTIVE METAL TABLE

Super Active Very Fast Cure	Active Fast Cure	Inactive Slow Cure	Passive Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes



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As Cured- Physical

ASTM D2240	Durometer Hardness, Shore A	24 points
ASTM D 412	Tensile Strength	2.4Mps (350psi)
ASTM D 412	Elongation	600%
ASTM D 746	Brittle Point	-73°C

Storage

When stored in original unopened container at or below 32°C, Red Hi-Temp RTV Silicone Gasket Maker has a shelf life of 15 months from date of shipment. Containers should always be kept sealed when not in use. After a container has been opened, a plug of cured material may form in the nozzle or tube tip during storage. When ready to reuse, unscrew the nozzle and remove the cured plug. The remaining sealant is ready to use.

Presentation

Red Hi-Temp RTV Silicone Gasket Maker is available in 108g Tube.

Cure Time

Cure time is affected by relative humidity, degree of confinement and cross-sectional thickness of the sealant. Sections up to 1/8 inch thick become rubbery solids in about 24 hours at room temperature at 20 percent relative humidity.

More moisture content reduces cure time slightly. In 24 hours, sections up to 1/8 inch thick cure to a rubber with a Shore A Durometer hardness of about 20 points. After 3 days at room temperature, this durometer hardness levels off to about 24 points.

In applications where Red Hi-Temp RTV Silicone Gasket Maker may be partially or totally confined during cure, the time required for proper cure is generally lengthened by the degree of confinement. It is possible that with absolute confinement cure will not be completed. The result is the softening of the sealant at elevated temperatures. Metal-to-metal bonds should not overlap more than one inch. Every application involving confinement during cure should be thoroughly tested before commercialisation.

Curing time increases with the thickness of the sealant. A 1/2-inch cross section, for example, may require 3 or 4 days for complete solidification.

However, the cure will have penetrated the outer 1/8 inch in about 24 hours.

Adhere to glass, metal, or most woods, Red Hi-Temp RTV Silicone Gasket Maker has typical peel strength of 20 pounds per inch. After 72 Hours at room temperature.

An odour caused by the liberation of acetic acid is given off during cure. This odour disappears as the cure progresses and is not detectable after cure is complete.

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